

Claims

1. Method for the continuous production of infusion bags, in particular for tea, by depositing single substance quantities (3) on a filter paper web (2) and forming a tube as well as forming individual chambers (6), which are closed on all sides and at least contain one substance quantity (3), respectively, and which are attached to a carrier material (12),

**characterized in**

that the chambers (6) are formed by a transverse seam (9), which simultaneously comprises the rear seam (9a) of the one infusion bag and the front seam (9b) of the succeeding infusion bag and a perforation (9c) interposed between both seams (9a, 9b), at which the infusion bags are separated in course of the process.

2. Method according to claim 1, characterized in that the transverse seam (9) is produced by ultrasound.
3. Method according to claim 1 or 2, characterized in that two corners (9d) are punched laterally of a central web during the production of transverse seam (9) and front seam (9b) is V-shaped.
4. Method according to one of the claims 1 through 3, characterized in that the chambers (6) of the chamber tube are isolated by extension at perforation (9c) and thereafter attached to a carrier material web (12).
5. Method according to claim 4, characterized in that the attachment is carried out by welding by means of ultrasound.
6. Method according to claim 4 or 5, characterized in that carrier material web (12) is perforated before the attachment or simultaneously with the attachment.
7. Method according to at least one of the claims 1 through 6, characterized in that the isolated chambers (6) of two chamber tubes are simultaneously or successively attached to carrier material web (12).

8. Method according to at least one of the claims 1 through 7, characterized in that the chambers (6) to be attached to carrier material web (12) are isolated by extension.
9. Method according to one of the claims 1 through 8, characterized in that the chambers (6) are formed by ultrasound welding of at least two filter paper webs, which are placed in parallel to each other and/or superposed.
10. Apparatus for the continuous production of infusion bags, in particular for tea, comprising a dosing device(1, 1a) for substance quantities (3) and a device for forming a tube, which is divided into single chambers (6) by transverse sealing, **characterized in** that in the transverse sealing station (5, 5a) a sonotrode (7) is arranged, which cooperates with a sealing roller (8) comprising recesses (8a) for the substance quantities (3) contained in the chambers (6), in order to produce a double seam (9) separated by a perforation (9c) and that another station (10, 10a) is provided, in which the chambers (6) are isolated by extension and attached to carrier material web (12).
- 11.Apparatus according to claim 10, characterized in that the other station (10, 10a) is also provided with a sonotrode (14, 16) and a sealing roller (11, 15) for welding the isolated chambers (6) to carrier material web (12) by ultrasound.
- 12.Apparatus according to claim 10 or 11, characterized in that in a similar additional station (10a) the chambers (6) of a second chamber tube are welded to carrier material web (12).
- 13.Apparatus according to one of the claims 10 through 12, characterized in that a separating station (17) is provided for isolating the sections of carrier material web (12), which are respectively connected to one or two chambers (6).
14. Infusion bag, in particular for tea, formed by at least one chamber (6) containing a substance quantity of the substance to be leached out and being produced by transverse sealing of a tube made of filter material, and a section of a carrier

material web (12) connected to the chamber (6), characterized in that the transverse seams (9) of chamber (6) and/or carrier material (12) are welded to the chamber by ultrasound.

15. Infusion bag according to claim 14, characterized in that the transverse seam is formed by a double seam (9) comprised of a front and a rear seam (9a, 9b) having a perforation (9c) placed in between.